Bate:

Friday, 14/11/2008 10:21:12 AM

User: Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 43447

Estimate Number

: 11152

P.O. Number

Prsht Rev.

This Issue

: 14/11/2008

: NC

First Issue Previous Run : // : 37073

Type : MACHINED PARTS **Part Number**

Drawing Name

: D32331

Drawing Number

: D3233 REV B

: INSIDE WASHER

Project Number

: N/A : B

Drawing Revision

Material

Due Date

: 28/11/2008

Qty:

10 Um:

Each

Written By Checked & Approved By

Comment

: Est. B 05.03.31

S.O. No. :

Added Powder Coat

KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1020-1025 round tubing 2.00 x .500w

1.0

Comment: Qty.:

M1020TR2000W500

0.6563 f(s)

1020-1025 Round Tube

0.0656 f(s)/Unit

Material: AISI 1020-1025 Seamless Tubing 2" x 0.500" wall

Total:

(M1020TR2.000W.500)

Identify for D3233-1

Batch: MODIO

ostulio My

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL Turn as per Folio FA517 and Dwg D3233

Deburr

08/11/16

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

POWDER COATING

5.0

POWDER COATING







Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

Dart Aerospace Ltd

Dail ACI	uspace	; Liu						
W/O:				WORK ORDER CHANG	ES			
DATE STEP		I	PROCEDURE (CHANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault C	Category:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	Dispos	sition:	_ QA: N/C Clo	sed:	Date: _	
NCR:			WORK O	RDER NON-CONFORMA	ANCE (NCR)		
	T	Description of NC		Corrective Action Section	on B	Verification Approva		Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
			i i					

NOTE: Date & initial all entries

Friday, 14/11/2008 10:21:12 AM Date: Julie Dawson User: **Process Sheet** Drawing Name: INSIDE WASHER Customer: CU-DAR001 Dart Helicopters Services Part Number: D32331 Job Number: 43447 Job Number: Seq. #: Description: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE u 58,11.20 Job Completion

Dart Ae	rospace	e Ltd								
W/O:			W	ORK ORDER CH	ANGES					
DATE STEP		PRO	OCEDURE CHA	ANGE		Ву	Date	Qty Chief	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·· · · · · · · · · · · · · · · · · · ·		•								
Part No	:	PAR #:	Fault Cat	egory:	NCF	R: Yes I	No DQ	A:	Date: _	
	. R	esolution:							Date: _	
NCR:			WORK ORE	DER NON-CONFO	RMANCE	(NCR))			
DATE	STEP	Description of NC	Initial	Corrective Action Action Descrip	Section B	Sign &	Verific			Approval
		Section A	Chief Eng	Chief Eng	7.1011	Date	Secti	on C	Chief Eng	QC Inspector

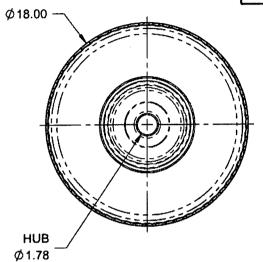
NOTE: Date & initial all entries

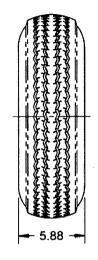
DART AEROSPACE LTD	Work Order: レ344	7
Description: Inside Washer	Part Number: D323	3-1
Inspection Dwg: D3233 Rev: B	Page 1	of 1

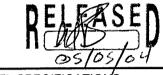
FIRST ARTICLE INSPECTION CHECKLIST								
	>	First Arti	icle	Prot	otype			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		nments	
0.620	+0.000/-0.010	.615						
0.265	+0.005/-0.000	, 267						
Ø1.378	+/-0.010	1.3765						
Ø1.190	+/-0.005	1, 191						
Ø2.00	+/-0.030	1.9985						
Ø1.500	+/-0.010	1,500						
				·				
			ļ <u>-</u> <u>-</u>					
	er e							
							·	
					·		·	
Measured by:		Audited by:	18		Prototyp	e Approval:	N/A	
Date:	04/11/16	Date:	08/11/	//7		Date:	N/A	
Rev Date	Change					Revised by	Approved	
A 05.04.26	New Issue			_		KJ/JLM 🚓		



DESIGN 3		GN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECK	¥ ED	APPRÉ		DRAWING NO. D3233	REV. B SHEET 1 OF 3		
DATE		, - <u></u>		TITLE	SCALE		
	05.0	03.08		WHEEL ASSEMBLY	1:1		
Α	0	5.02.18	,	NEW ISSUE			
В	05.03.08			ADDED BEARING SEALS			

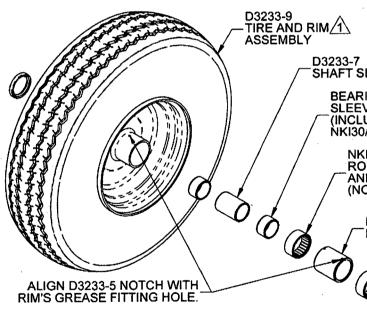






WHEEL SPECIFICATIONS					
SIZE	MAXIMUM LOAD	MAXIMUM INFLATATION LOAD			
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*			

* MANUFATURER'S RECOMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.



SHAFT SLEEVE (1)

BEARING INNER SLEEVE (2) (INCLUDED WITH NKI30/20 BEARING)

NKI30/20 NEEDLE ROLLER BEARING (2) 2 3 AND BRASS SHIMS (8) (NOT SHOWN)

D3233-5 **HUB SLEEVE (1)**

CR 35x45x7 HMS4 R

BEARING SEAL WALBY P/N 35x45x7 OR

P/N 13927 (2 PLACES) SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
2) POSSIBLE SUPPLIER: GENERAL BEARING
3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
4) POSSIBLE SUPPLIER: GENERAL BEARING
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

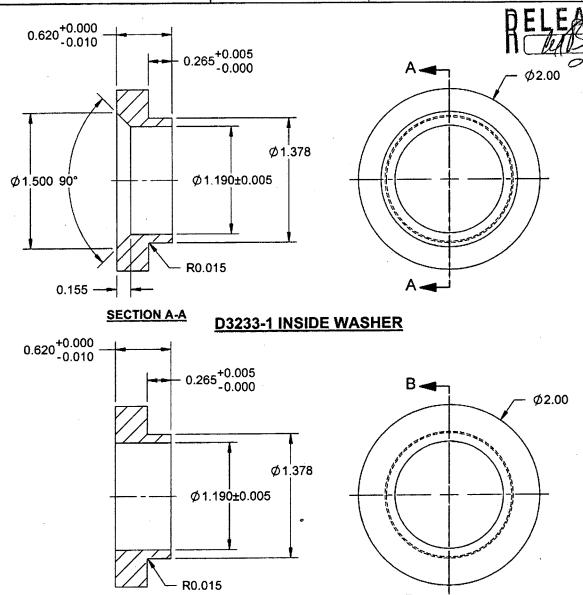
NOTES:

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

D3233-041 WHEEL ASSEMBLY



1			
DESIGN	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO,	
CHECKED	AMPROVED	DRAWING NO.	REV. B
	WAND	D3233	SHEET 2 OF 3
DATE		TITLE	SCALE
05	.03.08	WHEEL ASSEMBLY	1:1



D3233-3 OUTSIDE WASHER

SHOP COPY RETURN TO **ENGINEERING**

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 ONTROLLED COPY

 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESSET TO AMENDMENT (REF. DART SPEC. M1020TR)

 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3

 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 4) ALL DIMENSIONS ARE IN INCHES

- 4) ALL DIMENSIONS ARE IN INCHES

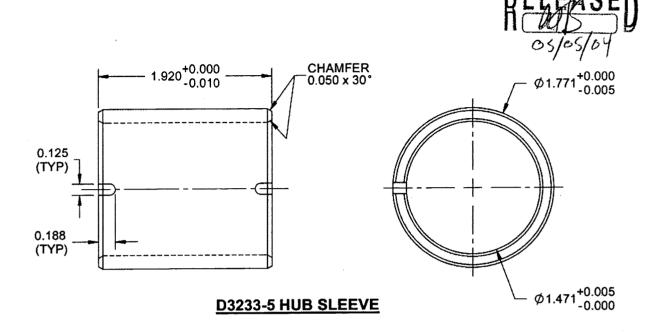
SECTION B-B

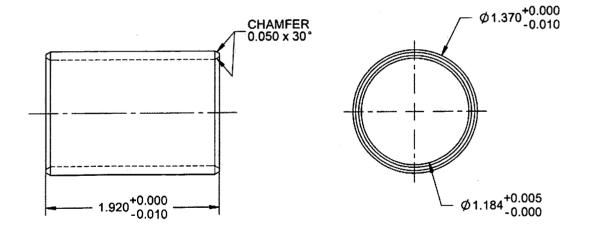
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.



	1		44 <u></u>
DESIGN 3	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO,	
CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 3 OF 3
DATE		TITLE	SCALE
05	.03.08	WHEEL ASSEMBLY	1:1





D3233-7 SHAFT SLEEVE

SHOP COPY

RETURN TO

ENGINEERING

NOTES:

1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00

MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS'T TO AMENDMENT (REF. DART SPEC. M1020TR)

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

4) BREAK ALL SHARP EDGES 0.010 TO 0.030

COPYRIGHT @ 2005 BY DART AEROSPACE LTD.